

Work Order ID 55471

January 19, 2010 12:43:01 PM

Page 1

Item ID: D120-638-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw

Start Date: 1/19/10 Start Qty: 4.00

Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: *PH*

Date: 10-1-19

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2435	Rev E1

100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D120-638-011 CHG 002								

S.0101/21

HJ for BG 10/01/20

160	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

Packaging	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Packaging

10-1-20 (4x) 50

170	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

> S.0101/21

(4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55471

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Page 2

Item ID: D120-638-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw

Start Date: 1/19/10 Start Qty: 4.00

Required Date: 1/25/10 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00


Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD120-638-011
Location: 19*Rec'd 1/22/10 (4)*

190

0.00


QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/01/25
MF 10-1-25

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 55471

Parent Item: D120-638-011

Parent Item Name: Bearpaw







Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B Added Step 2 08-04-16 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Start Qty: 4.00


Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2435 <i>+2</i>		Manufactured	No			160	Each	0.0000	8.0000			
<i>Sy</i> 											<i>B55 472 *8 10-1-20 sl</i>	
Bearpaw, 206												
D2182B050 <i>+4 @ 5.00"</i>		Manufactured	No			160	Each	0.0000	16.0000			
<i>Sy</i> 	<i>max 5.00 10/1/12</i>										<i>10-1-20 sl 52649</i>	
Clamp Cushion Black												
D2274 <i>LS</i>		Manufactured	No			160	Each	139.0000	32.0000			
<i>Sy</i> 											<i>10-1-20 sl</i>	
Radius Block												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST010	41	
52644	41	
Main Warehouse		
ST10	98	
<u>54850</u>	98	
	76.0000	16.0000

32

10-1-20 sl (4x)

D2438 *X4*
Sy 
Clamp

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	76	
46113	5	
<u>53221</u>	71	

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 55471

Parent Item: D120-638-011

Parent Item Name: Bearpaw


Comments: IPP Rev:A New Issue 07-01-02 JLM
 IPP Rev:B Added Step 2 08-04-16 JLM Verified By:EC
 IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Start Date: 1/19/10

Required Date: 1/25/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2529 		Manufactured	No			160	Each	730.0000	32.0000		10-1-20	sl
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST017

730

52745

730

160

Each

602.0000

32.0000

32

10-1-20

sl

AN4-15A 

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

602

113121

6

113538

400

113595

196

160

Each

149.0000

32.0000

32

10-1-20

sl

(40)

AN960JD416 

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

149

112314

149

16941

0

32

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D120-638-011



Parent Item Name: Bearpaw

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev:A New Issue 07-01-02 JLM
 IPP Rev:B Added Step 2 08-04-16 JLM Verified By:EC
 IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L4	X					160	Each	3,709.000	32.0000			
Nut												

8x



10-1-20

(40) SD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3709

102552

6

104248

6

110507

184

111827

2513

113422

1000

15924

0

32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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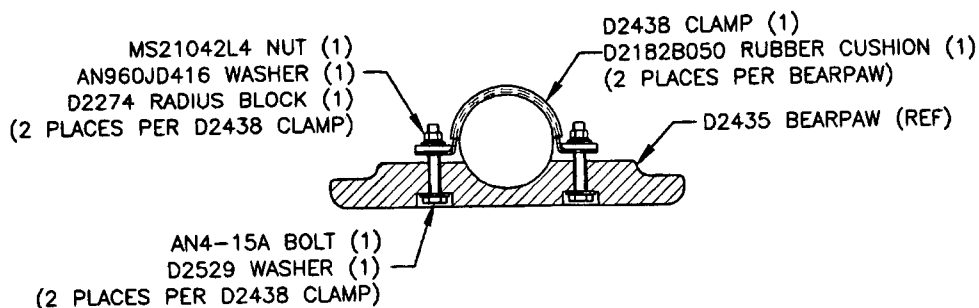


Figure 2 – Bearpaw Installation

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D120-638-011 Bearpaw	8.4 lb 3.82 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.7 in 4.54 m	1501.1 in-lb 17.34 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D120-638-011	BEARPAW INSTALLATION
4	D2182B050	Rubber Cushion
8	D2274	Radius Block
8	D2529	Washer
2	D2435	Bearpaw
4	D2438	Clamp
8	AN4-15A	Bolt
8	AN960JD416	Washers
8	MS21042L4	Nut (or MS21042-4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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